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006275

D4775-041
Job Sheet 184278



Part No: D4775-041

Job Qty: 6 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 0 5 2018
110	Packaging	6 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1-5		Smb
120	Small Fab	6 pcs	10/26/18	10/26/18	0.00	2.49	Small Fab-7		Smb DAS
130	QC	6 pcs	10/26/18	10/26/18	0.00	0.00	QC5		NOV 0 7 2018 68
140	Packaging	6 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-2		NOV 0 7 2018 9-89
150	QC21-SA	6 Ea	10/26/18	10/26/18	0.00	0.00	QC21		

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: 5096394 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

app 3/19

DAS NOV 0 8 2018
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	12 Ea (2 ea)	90-Start up Operation	5106952
D4775-1	Strut Tube	6 Ea (1 ea)	90-Start up Operation	5116144
D4776-1	Basket Strut Clevis	6 Ea (1 ea)	90-Start up Operation	5117066
D4776-5	Spacer	24 Ea (4 ea)	90-Start up Operation	5119995
D4777-1	Rod End Bearing	6 Ea (1 ea)	90-Start up Operation	5122103
MS21042L3	Nut	12 Ea (2 ea)	90-Start up Operation	5094592
MS21209-F615	Heli-Coil	6 Ea (1 ea)	90-Start up Operation	5103835

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	12	239	0
	D4775-1	6	11	0
	D4776-1	6	11	0
	D4776-5	24	0	0
	D4777-1	6	30	0
	MS21042L3	12	2,907	0
	MS21209-F615	6	108	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermal ☐ Large Tool ☐ Cross ☐ Machining ☐ Grinding ☐ Large Tool ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Repro/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____							
Description									
				MRB (QSI042) Approval					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

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Container No: S124653
 Part: D4775-041
 Job No: 184278
 Serial No/Batch: S124653
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Date: 11/05/16

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

Broken/Damage/Defect	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Inspection Incomplete/Unqualified	☐	Folio/Program	☐	Outside Dimensions	☐
Contamination	☐	Grain	☐	Over/Under tolerance	☐
Countersink	☐	Weld	☐	Part Incorrect	☐
Cut Too Short	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Instructions Incomplete/Unclear	☐	Out of Sequence	☐	Part Moved	☐
Drill Holes	☐	Off-set	☐	Drawing	☐
		Mislabeled	☐	Finish	☐
		Fit/Function	☐	Misread	☐
		Misaligned/off center	☐	Turning Sequence	☐

Specifications could not be found.

Plex 10/4/18 1:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			